

642-511

Dart Aerospace Ltd.

Date: Wednesday, 13/05/2009 11:30:16 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE ASSEMBLY
Job Number	: 47938A		
Estimate Number	: 10309		
P.O. Number	:	Part Number	: D206642541
This Issue	: 13/05/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3274 REV D
First Issue	: / /	Project Number	: N/A
Previous Run	: 47937A	Drawing Revision	: D
	Type : SKIDTUBES	Material	:
Written By	:	Due Date	: 29/05/2009
Checked & Approved By	: <u>JUDON.05.13</u>	Qty:	1 Um: Each
Comment	: Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM Est Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM Est Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD Est Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC Est Rev:F 08-06-02 add comment DD verified by:EC Est Rev:G 08-10-09 revise details DD verified by:EC		

Additional Product

f tube is scrap f

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D206-642-541 CHG003		
2.0	D26001190	Extrusion Round 3" 206
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2600-1-190 3" OD Tube <u>B-47575</u> <i>MB 09-06-01 ①</i>		
3.0	D32851	Cap
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3285-1 Fwd Cap <u>B-47635</u> <i>BE 09-06-01</i>		
4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd end of tube with saw table setup D3274. 2- remove fwd indexing ridge as per dwg D3274. Prepare for welding <i>M 9-6-1</i>		

MB 09-06-01 ①

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Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch: m/09213/m111679 BE 09-06-01

4- grind fwd cap weld on top surface only BE 09-06-01

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

AWM 9-6-3

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



m/09-06-03



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

509/06/03 (K)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/06/03 (K)

8.0

D3282041

Float Web (206L/407)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web 47593 D M 9-6-3

9.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

AWM 9-6-3

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Job Number: 47938A

Part Number: D206642541

Job Number:



Seq. #: Machine Or Operation: Description :

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

Sikaflex expire date:

Start:

Finish:

(Adhere for 12 hours)

M 11/55
12-1-10
4:10
38:00AM

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soldered (X)

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

09-06-04

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

AWM 9-6-5

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soldered (X)

13.0

D2649

Cross Bolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 D2649

Crossbolt spacer

245317

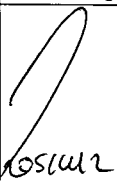

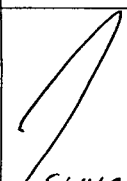
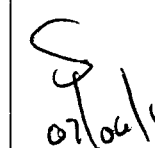
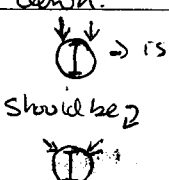

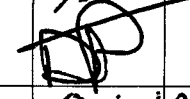
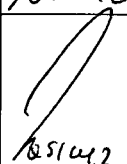
BE

9-6-8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-541 PAR #: _____ Fault Category: Prod/Kk tube NCR: (Yes) No DQA: D Date: 09/06/10
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: A Date: 09/06/10

NCR: <u>47938A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/6/8	# 11.2	Found Duesin grinding. That the wear plate holes are all elongated. Not acceptable. Holes were drilled straight to 1. 2.5 diam.		Tube is scrap too many holes to re-work, and cannot install back plug beyond the band to eliminate weld cracks in the tube.	W 9-6-10			
		RC. L.O.A  is should be 2		Retrain employee on process.	AWM 9-6-10 			
					9-6-10			

NOTE: Date & initial all entries

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Part Number: D206642541

Job Number:



Seq. #: Machine Or Operation: Description :

14.0 D32751 Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1 Crossbolt spacer

B 48117 BE 09-06-08

15.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod

m109213 BE 09-06-08

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

16.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

18.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

19.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

(P10) => Previous Page

SCANNED

Date: Wednesday, 13/05/2009 11:30:16 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 47938A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

21.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate

22.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet

SCRAP

23.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet

24.0

ALS71032130

Insert



Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Insert

Batch:

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

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Job Number: 47938A

Part Number: D206642541

Job Number:



Seq. #: Machine Or Operation: Description :

A/R Sikaflex-291 _____
Sikaflex expire date: _____

26.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inspect Nut Plate & Inserts

27.0 AN3C4A BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)
BOLT
Batch: _____

28.0 D353515 Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: _____

29.0 D353523 Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: _____

30.0 D353535 Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: _____

31.0 D353539 Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: _____

32.0 D353615 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: _____

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Job Number: 47938A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	D353623	Gasket
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: _____

34.0	D353635	Gasket
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: _____

35.0	D353639	Gasket
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: _____

36.0	D35371	Wearpad
------	--------	---------



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)
WEARPAD
Batch: _____

37.0	D35373	Wearpad
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPAD

38.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)
Pick:
Qty Part Number Description Batch
80 AN960C10L Washer _____

39.0	D36721	Phenolic Washer
------	--------	-----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
batch _____

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Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 47938A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring

41.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt

42.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960C416 Washer

43.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274

A/R Sikaflex-291

Sikaflex expire date:

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch:

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Job Number: 47938A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 _____

Sikaflex expire date: _____

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: _____

47.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Sample

*MF
09-06-10*

DART

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED07.02.12 **[Signature]**

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

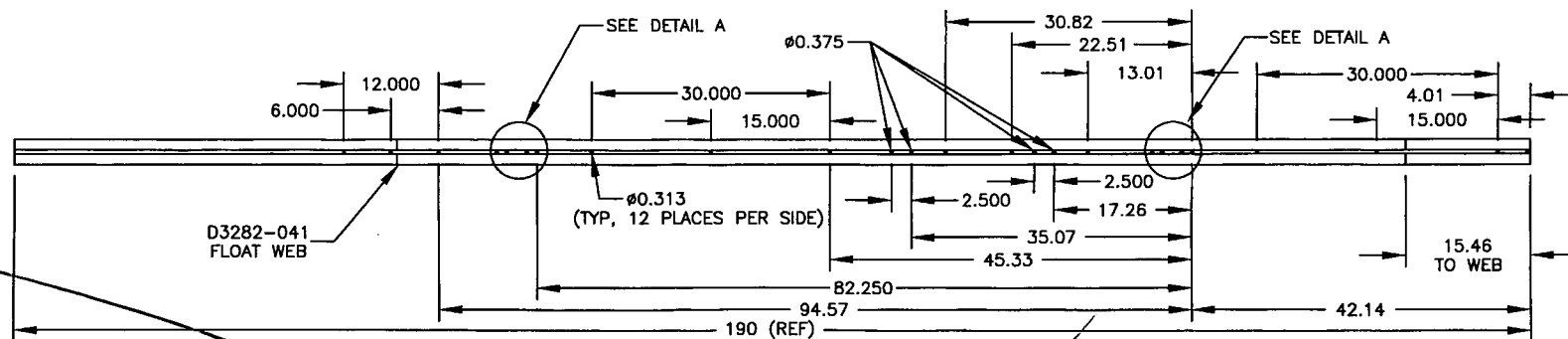
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH/ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

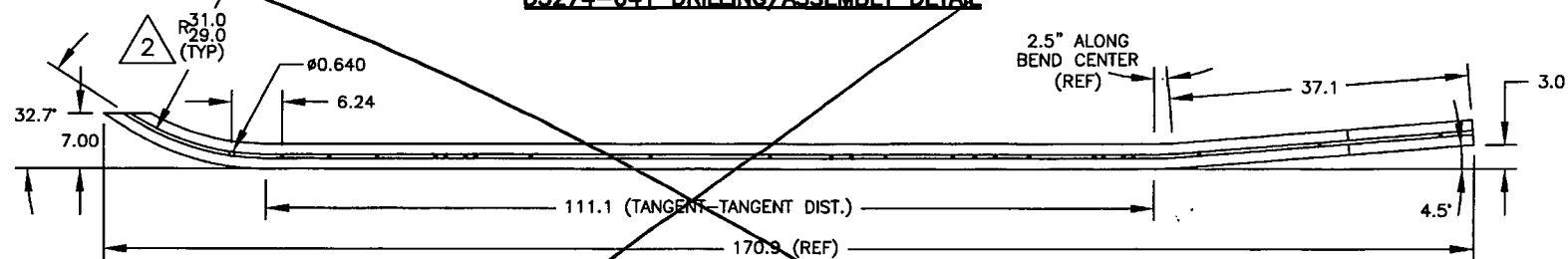
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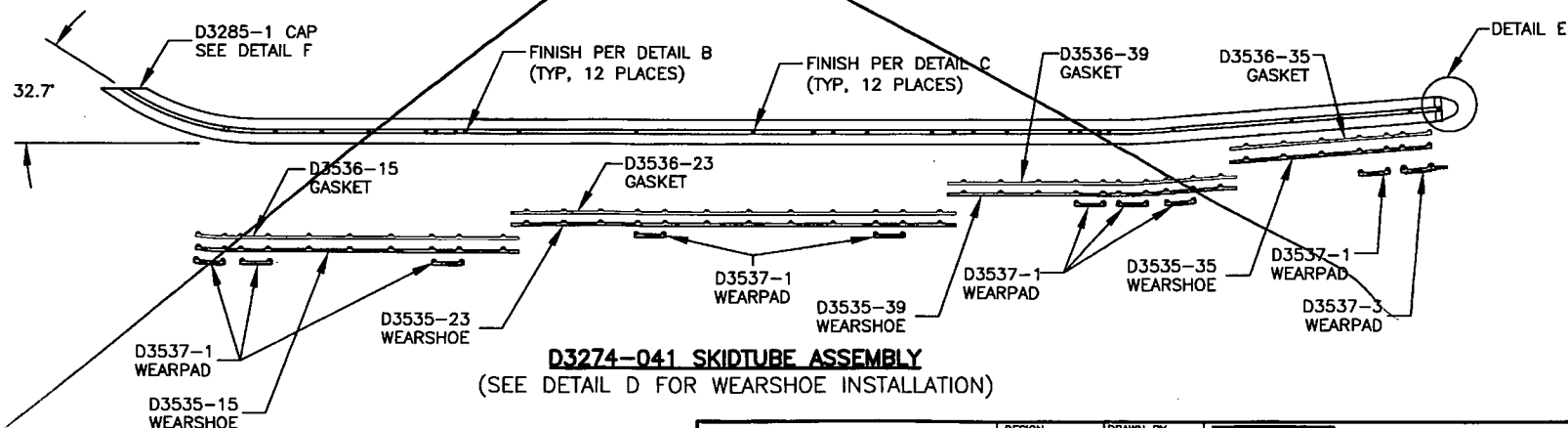
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D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

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CHECKED	APPROVED	D3274	SHEET 2 OF 4		SCALE
DATE	06.12.19		TITLE		1:15
			SKIDTUBE ASSEMBLY		



07.02.12

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DESIGN

DRAWN BY

DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

CHECKED

APPROVED *AI*

	DRAWING NO
--	------------

REV. D

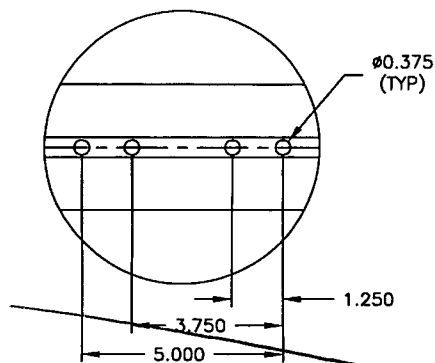
DATE	06.12.19
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TITLE	SKIDTUBE ASSEMBLY
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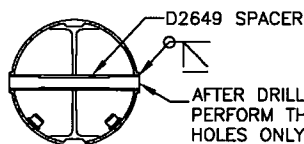
SCALE

1:15

DETAIL A: DRILL DETAIL

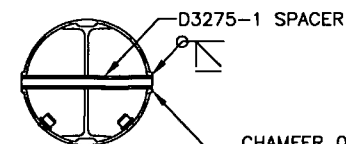


DETAIL B FOR 0.375 HOLES ONLY



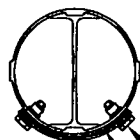
- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

DETAIL D



- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL F: END FINISHING DETAIL

CCR264SS3-3 RIVETS (2 PLACES)
INSTALL WITH LPS-3

CR3212-4-03 RIVETS (2 PLACES)
INSTALL WITH LPS-3

D3415-041 NUT PLATE,
LPS-3 ON FAYING SURFACE, LPS HARDCOAT ON EXTERIOR

D3413-1 RING

D3285-1 CAP (REF)

1/16

1.0
REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

ORIENTATION
OF D3415-041

RELEASED
07.02.12

DETAIL E

- AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

D2646 CAP
SEAL WITH
SIKAFLEX-241/291
ADHESIVE

0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

0.400

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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DESIGN

CP

DRAWN BY

PH

DART

DART AEROSPACE USA, INC.

PORT HADLOCK, VA

CHECKED

APPROVED

DATE

06.12.19

DRAWING NO.

D3274

TITLE

SKIDTUBE ASSEMBLY

REV. 0

SHEET 4 OF 4

SCALE

1:3

NO. 193817
WORK ORDER
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